

**Work Order ID 67228**

Friday, March 11, 2011 2:53:42 PM



Page 1

Item ID: D4148-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crossstube Lug Assembly, Fwd

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: UMFDate: 11-03-11

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

Draw Nbr

Revision Nbr

D4148

D

100

0.00



Small Fab

Memo

0.00

Small Fab

1- Assemble as per dwg

ES 11/03/14 ①

110

0.00



QC

QC5- Inspect part completeness to step on W/O

Memo

0.00

Quality Control

5/11/03/14

⑦

120

0.00



Packaging

Identify as per dwg & Stock Location: Y6B

Memo

0.00

Packaging

11/13/14 ⑫

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

**Work Order ID 67228**

Friday, March 11, 2011 2:53:42 PM



Page 2

Item ID: D4148-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/14/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 3/16/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/3/15 *[Signature]*  
INF  
11-03-14

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries




Friday, March 11, 2011 2:53:39 PM

[illegible][illegible]

**Required Date:** 3/16/2011

**Required Qty: 1.00**

IPP Rev:C  
IPP REV:D 11.03.02

| Component Item ID/<br>Item Name                                                                                 | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty    | Qty<br>Issued | Date<br>Issued | Status |
|-----------------------------------------------------------------------------------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|-----------------|---------------|----------------|--------|
| D2690-6<br><br>Lanyard Assembly |                        | Manufactured  | No          |                     |                  | 100             | Each               | 45.0000        | 1           | 1               |               | 03/14          |        |
|                                                                                                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |        |
|                                                                                                                 |                        |               |             | ST020               |                  |                 |                    | 45             |             |                 |               |                |        |
|                                                                                                                 |                        |               |             | 59960               |                  |                 |                    | 1              |             |                 |               |                |        |
|                                                                                                                 |                        |               |             | 66029               |                  |                 |                    | 4              |             |                 |               |                |        |
|                                                                                                                 |                        |               |             | 66509               |                  |                 |                    | 20             |             |                 |               |                |        |
|                                                                                                                 |                        |               |             | 66873               |                  |                 |                    | 20             |             |                 |               |                |        |
| D3910-1<br><br>Crosstube Lug    |                        | Manufactured  | No          |                     |                  | 100             | Each               | 13.0000        | 1           | 1               |               | 03/14          |        |
|                                                                                                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |        |
|                                                                                                                 |                        |               |             | st507               |                  |                 |                    | 13             |             |                 |               |                |        |
|                                                                                                                 |                        |               |             | 59349               |                  |                 |                    | 1              |             |                 |               |                |        |
|                                                                                                                 |                        |               |             | 59708               |                  |                 |                    | 1              |             |                 |               |                |        |
|                                                                                                                 |                        |               |             | 65631               |                  |                 |                    | 11             |             |                 |               |                |        |
| D4091-1<br><br>Mounting Lug   |                        | Manufactured  | No          |                     |                  | 100             | Each               | 21.0000        | 1           | 1               |               | 03/14          |        |
|                                                                                                                 |                        |               |             | <u>Location</u>     |                  |                 |                    | <u>Loc Qty</u> |             | <u>Loc Code</u> |               |                |        |
|                                                                                                                 |                        |               |             | ST460               |                  |                 |                    | 21             |             |                 |               |                |        |
|                                                                                                                 |                        |               |             | 60239               |                  |                 |                    | 1              |             |                 |               |                |        |
|                                                                                                                 |                        |               |             | 65626               |                  |                 |                    | 20             |             |                 |               |                |        |

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, March 11, 2011 2:53:39 PM

Page 2

Work Order ID: 67228

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/14/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

D4148-1 Manufactured No

100 Each

6.0000

2



Crosstube Lug Plate, Fwd

Location

Loc Qty

Loc Code

ST133

6

D4148-3 Manufactured No

100 Each

1.0000

1



Stud Receiver, Lower

Location

Loc Qty

Loc Code

ST133

1

63722

1

D4148-5 Manufactured No

100 Each

5.0000

1



Eyebolt Stud

Location

Loc Qty

Loc Code

GA

4

66890

4

ST133

1

66974

1

\*N3C12A Purchased No

100 Each

88.0000

2



Bolts

Location

Loc Qty

Loc Code

ST351

88

112314

8

114761

11

116022

2

116289

17

116924

50

EP 11/03/14  
B66 889 (2x)

EP 11/03/14

EP 11/03/14

EP 11/03/14

116788 (2x)

Friday, March 11, 2011 2:53:39 PM

Shop Packet Print

Page 2

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



# Picklist Print

Friday, March 11, 2011 2:53:39 PM

Page 3

Work Order ID: 67228

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/14/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

AN4C13A Purchased No 100 Each 42.0000 3  
BOLT

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST357    | 42      |          |
| 113359   | 3       |          |
| 114442   | 5       |          |
| 114615   | 2       |          |
| 116914   | 32      |          |

MS17984-C413 Purchased No 100 Each 20.0000 1  
PIN, QUICK RELEASE

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST315    | 20      |          |
| 114774   | 1       |          |
| 116823   | 19      |          |

MS20615-4M18 Purchased No 100 Each 174.0000 8  
Rivet

| Location | Loc Qty | Loc Code |
|----------|---------|----------|
| ST323    | 174     |          |
| 114808   | 128     |          |
| 115037   | 46      |          |

MS2104308 -3 203.15 Purchased No 100 Each 0.0000 2  
Nut

MS2104308 -4 203.15 Purchased No 100 Each 0.0000 3  
Nut

3  
3  
EPB 11/03/14

1  
1  
EPB 11/03/14

8  
8  
EPB 11/03/14

2  
2  
M112314  
EPB 11/03/14

3  
3  
M116188  
EPB 11/03/14

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

# Picklist Print

Friday, March 11, 2011 2:53:39 PM

Work Order ID: 67228

Parent Item: D4148-041

Parent Item Name: Crosstube Lug Assembly, Fwd

Start Date: 3/14/2011

Required Date: 3/16/2011

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0332R Purchased No

100

Each

1,962.000

4

4



Washer



*EP 3/11/03/14*

Location

Loc Qty

Loc Code

ST297

1962

115000

125

115698

35

116025

28

116304

1774

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
4

NAS1149C0432R Purchased No

100

Each

1,954.000

6

6



Washer



*EP 3/11/03/14*

Location

Loc Qty

Loc Code

ST297

1954

114292

12

116304

73

116805

19

116900

1850

\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
\_\_\_\_\_  
6

| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |  |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|--|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |  |
|      |      |                    |    |      |     |                                     |                          |  |
|      |      |                    |    |      |     |                                     |                          |  |

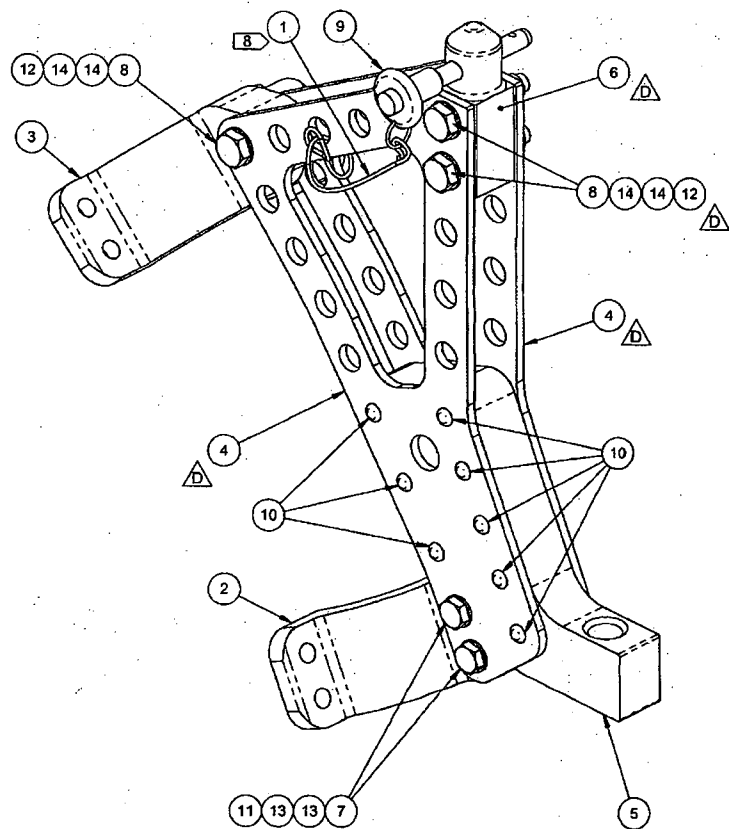
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

8 7 6 5 4 3 2 1



**D4148-041 FWD X-TUBE LUG ASSY**

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4148-041" PER DART QSI 044 6.1
- 7) WEIGHT: 3.67 lbs
- 8) ATTACH D2690-6 TO D4148-1 BY LOOPING AROUND A LIGHTENING HOLE FIRST AND THEN SECURE TO MS17984-C413

| ITEM | QTY<br>-041 | P/N           | DESCRIPTION          |
|------|-------------|---------------|----------------------|
|      | X           | D4148-041     | FWD X-TUBE LUG ASSY  |
| 1    | 1           | D2690-6       | LANYARD              |
| 2    | 1           | D3910-1       | X-TUBE LUG           |
| 3    | 1           | D4091-1       | MOUNTING LUG         |
| 4    | 2           | D4148-1       | FWD X-TUBE LUG PLATE |
| 5    | 1           | D4148-3       | STUD RECEIVER LOWER  |
| 6    | 1           | D4148-5       | EYEBOLT STUD         |
| 7    | 2           | AN3C12A       | BOLT                 |
| 8    | 3           | AN4C13A       | BOLT                 |
| 9    | 1           | MS17984-C413  | PIP PIN              |
| 10   | 8           | MS20615-4M18  | RIVET                |
| 11   | 2           | MS21043C2     | NUT                  |
| 12   | 3           | MS21043C4     | NUT                  |
| 13   | 4           | NAS1149C0332R | WASHER               |
| 14   | 6           | NAS1149C0432R | WASHER               |

#6628

**RELEASED**  
2011-02-24

|            |                                                                                                                                                                                                                                                                                                                     |                                                                                                                                                                                                                                                                |              |
|------------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| D          | HOLE DIA CHANGED TO 0.252" (D8-3); HOLE DIA CHANGED TO 0.250" (C8-5); REPLACED QTY(2) AN3C12A, MS21043C3 AND QTY(4) NAS1149C0332R WITH QTY(2) AN4C13A, MS21043C4 AND QTY(4) NAS1149C0432R (D3-1, C4-2)                                                                                                              | SC                                                                                                                                                                                                                                                             | 11.02.22     |
| C          | REDESIGNED D4148-1/3 TO ADDRESS COMPATIBILITY ISSUES WITH D350-591 SHORT STEPS                                                                                                                                                                                                                                      | MB                                                                                                                                                                                                                                                             | 10.10.12     |
| B          | REPLACED QTY(3) MS20615-4M18 WITH QTY(2) EACH AN3C12A, MS21043-3 AND QTY(4) NAS1149C0332R WASHER (ZN D3-1, B7-2 & B4-2); MS20615-4M18 WAS MS20615-4M20 (ZN D3-1 & B7-2); Ø0.191 2 PL REPLACES Ø0.129 3 PL (ZN D6-3); Ø0.129 7 PL WAS 10 PL (ZN A7-3); Ø0.191 WAS 0.129 (ZN C8-5); REASON: SEE TR-D350-607-2 REV. B. | MB                                                                                                                                                                                                                                                             | 10.07.05     |
| A          | NEW ISSUE                                                                                                                                                                                                                                                                                                           | MB                                                                                                                                                                                                                                                             | 10.06.18     |
| REV.       | DESCRIPTION                                                                                                                                                                                                                                                                                                         | BY                                                                                                                                                                                                                                                             | DATE         |
| DESIGN     | MB                                                                                                                                                                                                                                                                                                                  | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                       |              |
| DRAWN      | SC                                                                                                                                                                                                                                                                                                                  |                                                                                                                                                                                                                                                                |              |
| CHECKED    |                                                                                                                                                                                                                                                                                                                     | DRAWING NO.                                                                                                                                                                                                                                                    | REV. D       |
| MFG. APPR. |                                                                                                                                                                                                                                                                                                                     | D4148                                                                                                                                                                                                                                                          | SHEET 1 OF 5 |
| APPROVED   |                                                                                                                                                                                                                                                                                                                     | TITLE                                                                                                                                                                                                                                                          | SCALE        |
| DE APPR.   |                                                                                                                                                                                                                                                                                                                     | FWD X-TUBE LUG ASSY                                                                                                                                                                                                                                            | NTS          |
| DATE       | 11.02.22                                                                                                                                                                                                                                                                                                            | COPYRIGHT © 2010 BY DART AEROSPACE LTD<br>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. |              |

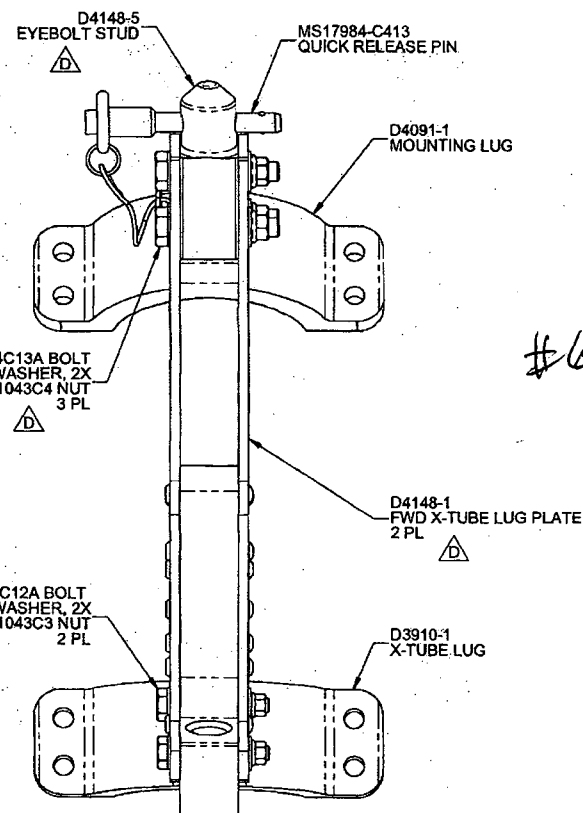
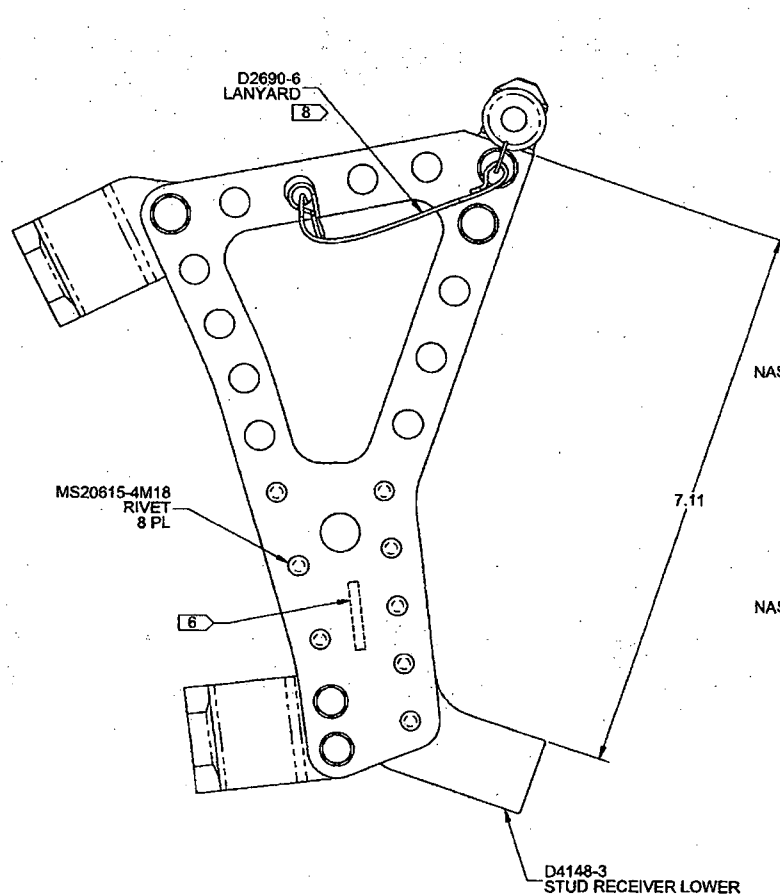
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
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|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



#67228

RELEASED  
2011-02-24

**D4148-041 FWD X-TUBE LUG ASSY**

|            |          |                                                                                                                                                                                                                                                                                               |              |
|------------|----------|-----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | MB       | <b>DART AEROSPACE LTD</b>                                                                                                                                                                                                                                                                     |              |
| DRAWN      | SC       | HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                                                                   |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                                   | REV. D       |
| MFG. APPR. |          | D4148                                                                                                                                                                                                                                                                                         | SHEET 2 OF 5 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                                         | SCALE        |
| DE APPR.   |          | FWD X-TUBE LUG ASSY                                                                                                                                                                                                                                                                           | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

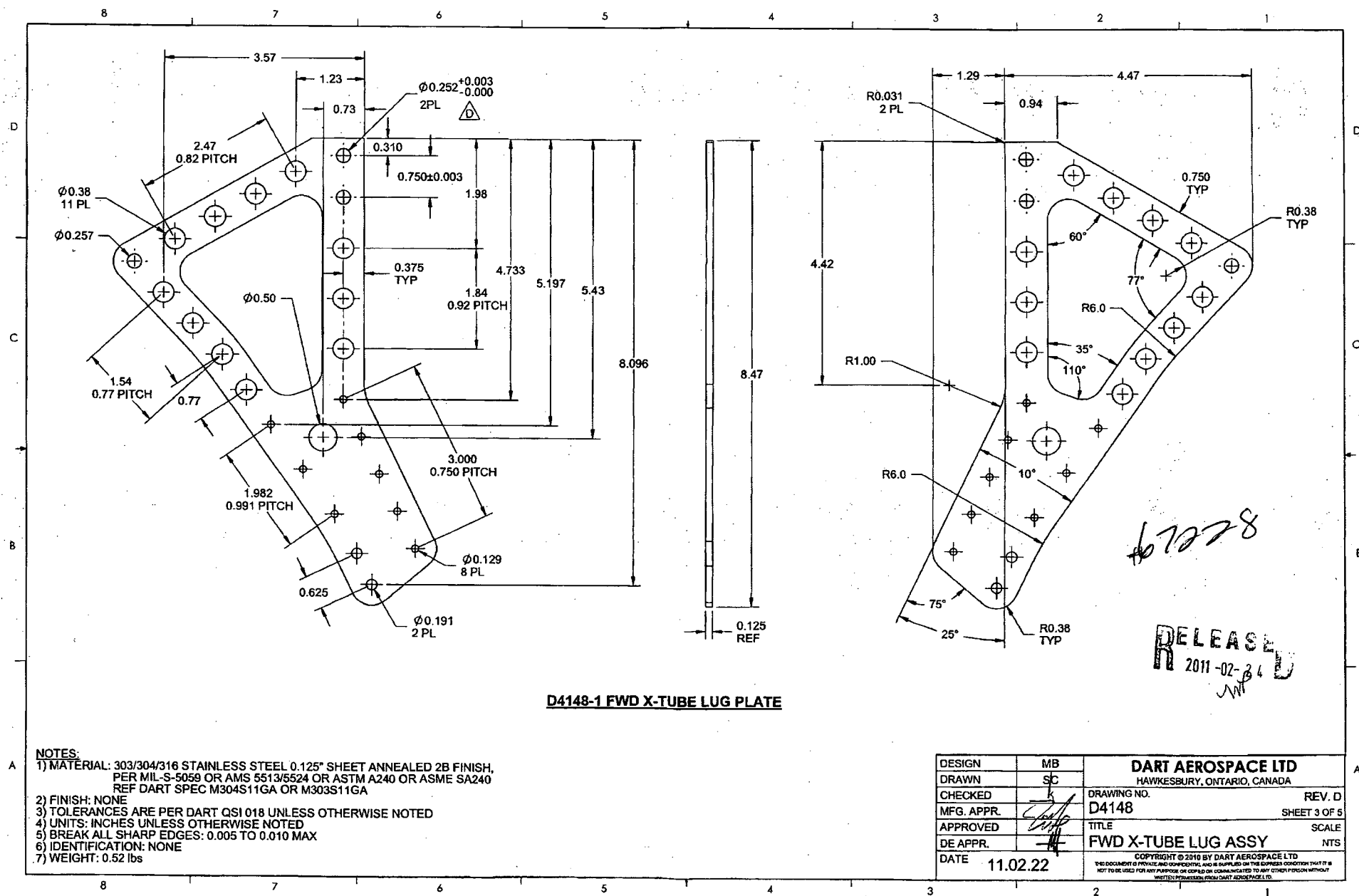
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries





| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

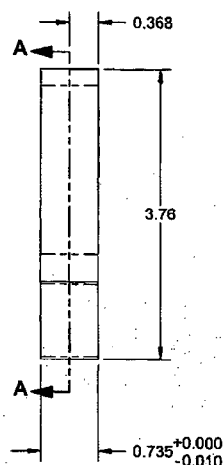
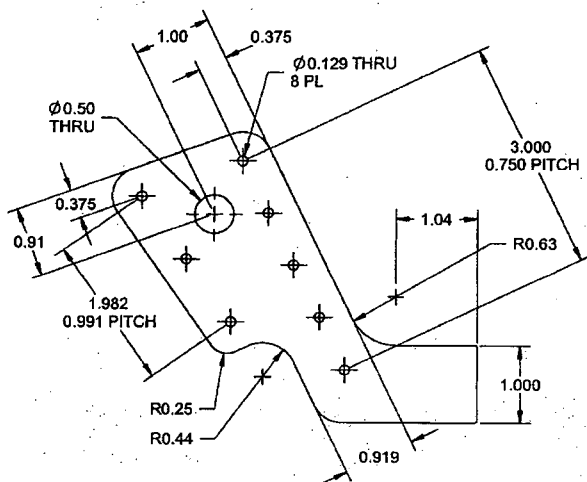
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

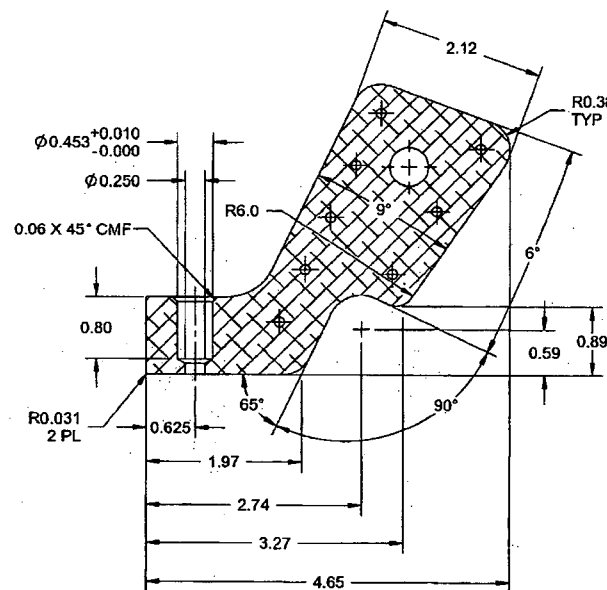
| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

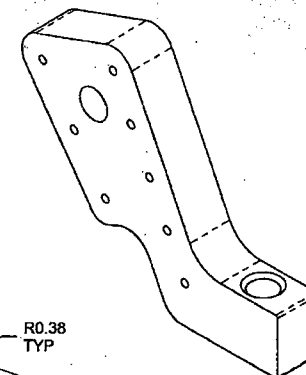
8 7 6 5 4 3 2 1



**D4148-3 STUD RECEIVER LOWER**



**SECTION A-A**



#67208

**RELEASED**  
2011-02-24

**NOTES:**

- 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
REF DART SPEC M304B OR M303B
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 1.52 lbs

|            |          |                                                                                                                                                                                                                                                                                 |              |
|------------|----------|---------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | MB       | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA                                                                                                                                                                                                                        |              |
| DRAWN      | SC       |                                                                                                                                                                                                                                                                                 |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                     | REV. D       |
| MFG. APPR. |          | <b>D4148</b>                                                                                                                                                                                                                                                                    | SHEET 4 OF 5 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                           | SCALE        |
| DE APPR.   |          | <b>FWD X-TUBE LUG ASSY</b>                                                                                                                                                                                                                                                      | NTS          |
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8 7 6 5 4 3 2 1

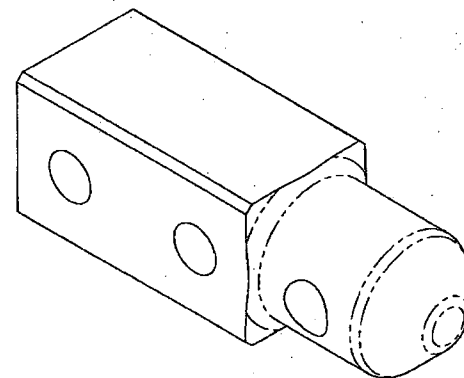
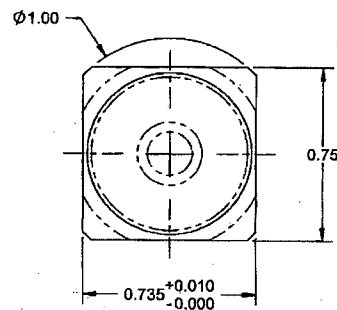
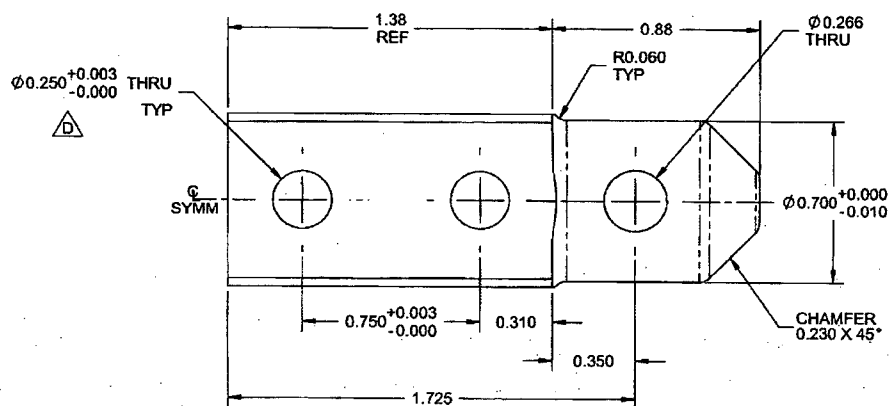
| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



**D4148-5 EYEBOLT STUD**

#67225

RELEASED  
2011-02-24

- NOTES:  
 1) MATERIAL: 303/304/316 STAINLESS STEEL BAR PER ASTM A582 OR ASTM A276  
 REF DART SPEC M304B OR M303B  
 2) FINISH: NONE  
 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK ALL SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 0.27 lbs

|            |          |                                                                                                                                                                                                                                                                                  |              |
|------------|----------|----------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------------|--------------|
| DESIGN     | MB       | <b>DART AEROSPACE LTD</b><br>HAWKESSBURY, ONTARIO, CANADA                                                                                                                                                                                                                        |              |
| DRAWN      | SC       |                                                                                                                                                                                                                                                                                  |              |
| CHECKED    |          | DRAWING NO.                                                                                                                                                                                                                                                                      | REV. D       |
| MFG. APPR. |          | D4148                                                                                                                                                                                                                                                                            | SHEET 5 OF 6 |
| APPROVED   |          | TITLE                                                                                                                                                                                                                                                                            | SCALE        |
| DE APPR.   |          | FWD X-TUBE LUG ASSY                                                                                                                                                                                                                                                              | NTS          |
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| W/O: |      | WORK ORDER CHANGES |    |      |     |                                     |                          |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |    |      |     |                                     |                          |
|      |      |                    |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                             |                                 |                |                           |                       |                          |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries